



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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13173

D4155-041 Job Sheet 189961



Part No: D4155-041

Job Qty: 10 pcs

DAS
21
9-88

Part Name: Wearbar Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 2/28/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG REV F IPP REV:A 15.10.16 AS PER DWG REV:F5 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	10 pcs	2/28/19		0.00	0.42	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		MAC
110	Automated Welding - B4B	10 pcs	2/28/19		0.00	7.81	Automated Welding - 1 - B4B		MAC
120	QC 10	10 pcs	2/28/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 38		
							QC 10 - 43		
							QC 10 - 50		CL
							QC 10 - 58		
							QC 10 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		



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Container No: S191088



Part: D4155-041

Job No: 189961

Serial No/Batch: S191088

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/18/19

Plex 2/1/19 10:05 AM Dart.Macdonald.Dara

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	CR
					QC 5 - 30	
140	Packaging 3-1 - Stock - B4B	10 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	CR
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	10 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21	DAS 21
					QC 21 - SA - 70	9-39
Part Op 100 - (Large Fab) Cut D4155-1 at 94.00" (EXTRA MATERIAL WILL BE CUT ON ASSEMBLY D4154-041) Descriptions: 110 - (Automated welding) 1- USE GRINDER TO CHAMFER END AS PER DWG . SEE "DETAIL B" ***SEE NOTE 9 FOR SURFACE BUILDUP*** USE DT9756 WELDING FIXTURE 120 - (QC10- Inspect visual per QSI004- ground welds) 130 - (QC5- Inspect part completeness to step on W/O) 140 - (Identify as per dwg & Stock Location: _____) LOCATION: WA002 150 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M304B0.250x0.500	304 Bar .250 X .500	78 ft (7.8 ea)	100-Large Fab - Welded Assy-1	S190032		

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M304B0.250x0.500	78	529	0
Part Specifications				
Specifications could not be found.				

Plex 2/1/19 10:05 AM Dart.Macdonald.Dara



Container No: S191088



Part: D4155 - 041

Job No: 189961

Serial No/Batch: S191088

Revision:

Inspector:

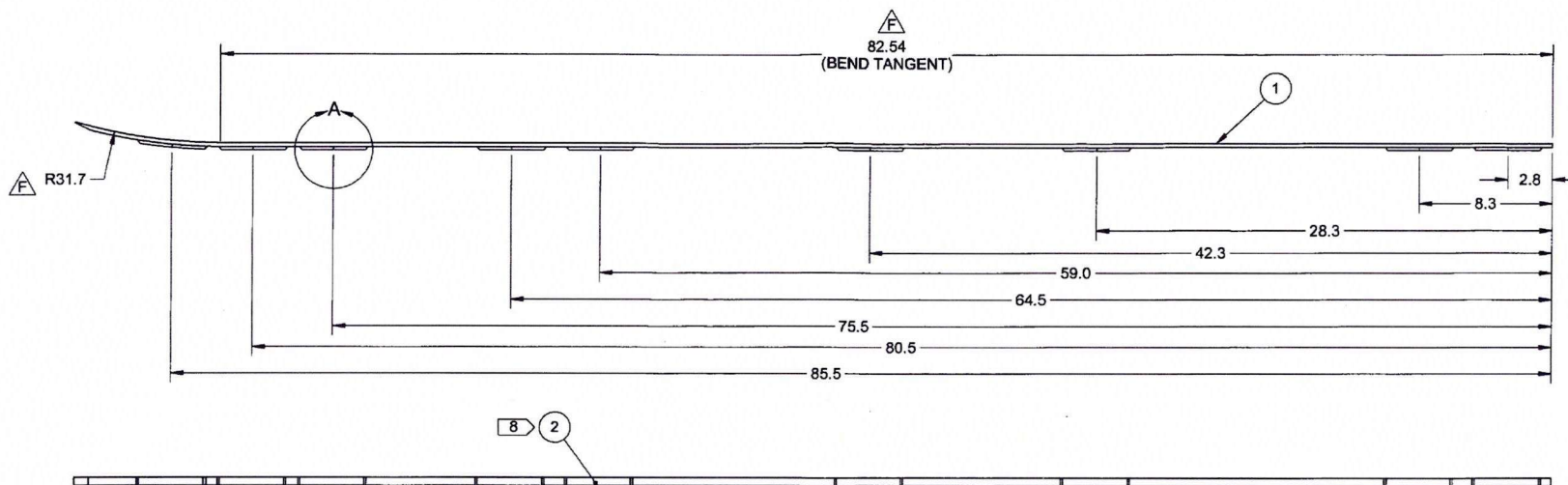
Exp Date:

Instructions: Various STC's

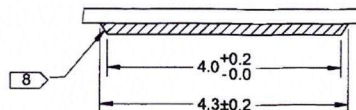
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Date: 06/17/19

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4155-041	WEARBAR ASSEMBLY
1	1	D4155-1	BAR
2	A/R	8259 \ 2059B	HARD SURFACING



D4155-041 WEARBAR ASSEMBLY



DETAIL A
9 PL
SCALE 3X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.42 lbs
- 8) BUILDUP HARD SURFACING 0.18 - 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.19 - 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

F	ADDED -041 ASSEMBLY. FWD END BEND DEFINED. NOTCHES REMOVED FROM -1 FOR NEW PROCESS	AJS	15.09.18
E	DIMENSION DATUM ON OPPOSITE END OF PART; 92.00 WAS 91.59. REF CIR12-10	SFM	13.02.20
D	REDESIGNED WITH SHORTER CUTOUTS. NOTE 8 ADDED. (PAR 12-213); 0.18 WAS 0.13	AJS	12.08.07
C	REMOVED TOOLING HOLE; ADD CUT OUT PROFILE (ZN C6-1 & C7-1); 2 DEC TOLERANCE (D1-1, D2-1)	RF	12.02.21
B	CHANGED MANUFACTURING PROCESS; MATERIAL WAS 0.50 THICK (A6-1); 0.25 REF WAS 0.20 (B6-1); 0.13 WAS 0.08 (B7-1)	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS	DRAWING NO. D4155 TITLE BAR	
DATE	15.09.18	REV. F SHEET 1 OF 2 SCALE NTS	

RELEASED
2015-12-07
SCN 15-051

APPROVED

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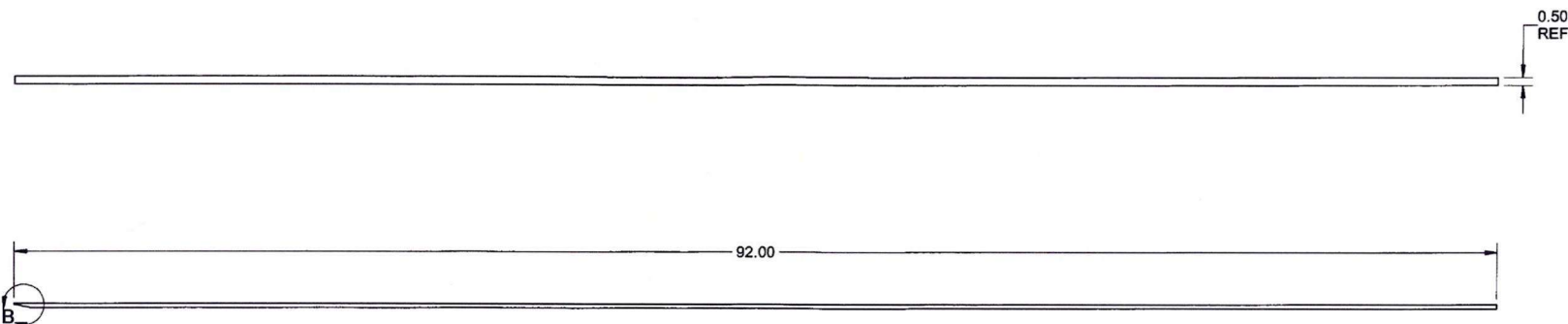
8 7 6 5 4 3 2 1

D

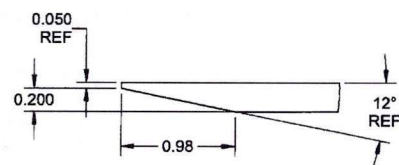
C

B

A



D4155-1 BAR



DETAIL B
SCALE 7X

NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL BAR, 0.25 THICK X 0.50 WIDE PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X0.500
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT: 3.29 lbs

RELEASE
2015-12-07

APPROVED

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	AP	DRAWING NO. D4155	REV. F
MFG. APPR.	JLM	SHEET 2 OF 2	
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BAR	NTS
DATE	15.09.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					